



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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RBE105-14181W6
Job Sheet 194408



Part No: RBE105-14181W6

Job Qty: 1 pcs **3**

Part Name: Flange Bushing Extractor



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/1/19

Job Tracking No:

Due Date: 6/10/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE105-14181W6 Rev.1 IPP Rev. A 18.10.19 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					M:s	Hrs			
90	Small Fab - Issue SN	1 pcs	6/10/19	6/10/19	0.00	0.00	Small Fab - 1		MLL
110	Small Fab - 2 - B4B	1 pcs	6/10/19	6/10/19	0.00	1.00	Small Fab - 1		MLL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	1 pcs	6/10/19	6/10/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
130	Packaging 3-1 - Stock - B4B	1 pcs	6/10/19	6/10/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		



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Container No: S187626



Part: RBE105-14181W6

Job No: 194408

Serial No/Batch: S187626

Revision: 1

Inspector:

Exp Date:

Instructions:

Date: 05/05/19

DAS
40
9-89

JUN 05 2019

DAS
28
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					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140 QC 21 - FG	1 pcs	6/10/19	0.00 0.00		QC 21 - FG - 21	
					QC 21 - FG - 70	
					QC 21 - SA - 53	

JUN 05 2019

R6001A

Part Op **110** - (Small Fab) 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Descriptions: Pelican case APP-1170-E 3-Debur holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue foam to case and pack case as per DWG.

120 - (QC5- Inspect part completeness to step on W/O)

130 - (Identify as per dwg & Stock Location: _____)

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RB41011	Dart Tooling Placard, Aluminum	1 pcs (1 ea)	90-Small Fab - Issue SN	512040
97524A032	Sealing Blind Rivet	4 Ea (4 ea)	110-Small Fab - 2 - B4B	5163934
APP-1170-E	Case	1 Ea (1 ea)	110-Small Fab - 2 - B4B	5184264
RBE105-14181W6-1	Plunger	1 pcs (1 ea)	110-Small Fab - 2 - B4B	5124615
RBE105-14181W6-11	Top Foam use in case APP-1170-E	1 Ea (1 ea)	110-Small Fab - 2 - B4B	5184278
RBE105-14181W6-3	Drift	1 pcs (1 ea)	110-Small Fab - 2 - B4B	5126176
RBE105-14181W6-5	Guide Bushing	1 pcs (1 ea)	110-Small Fab - 2 - B4B	5126690
RBE105-14181W6-7	Support	1 pcs (1 ea)	110-Small Fab - 2 - B4B	5123796
RBE105-14181W6-9	Bottom Foam use in case APP-1170-E	1 Ea (1 ea)	110-Small Fab - 2 - B4B	5184271

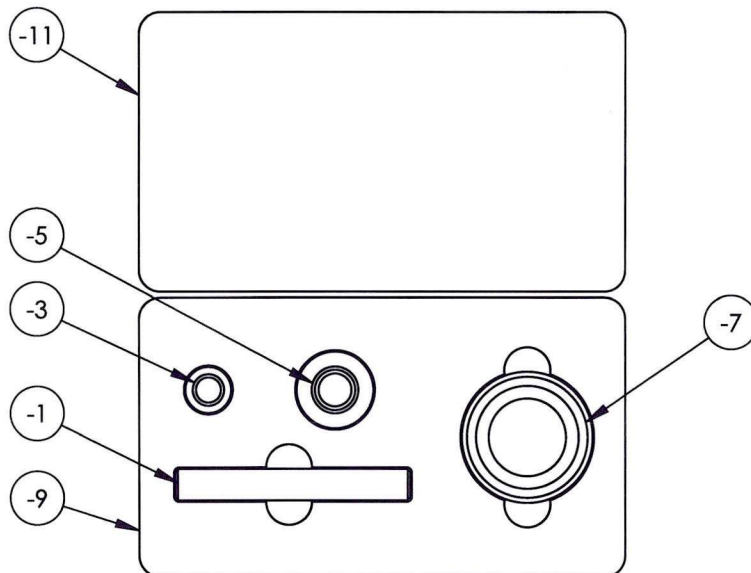
010171

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Small Fab - Issue SN	RB41011	1	318	0
110-Small Fab - 2 - B4B	97524A032	4	265	0
	APP-1170-E	1	9	0
	RBE105-14181W6-1	1	5	0
	RBE105-14181W6-11	1	3	0
	RBE105-14181W6-3	1	5	0
	RBE105-14181W6-5	1	4	0
	RBE105-14181W6-7	1	5	0
	RBE105-14181W6-9	1	3	0
Part Specifications				
Specifications could not be found.				

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	5/24/2016	RJC	JAG



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WITHOUT NOTICE
WORK ORDER
NO. 194408 M15
1905-01

NOTE:
REF. EUROCOPTER T/N 105-14181W6.

DART AEROSPACE															
TITLE PUSHING-OUT TOOL															
DWG NO. RBE105-14181W6	REV 1														
<table border="1"> <tr> <td>MAT'L</td> <td rowspan="4"> UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125° </td> </tr> <tr> <td>HEAT TREAT</td> </tr> <tr> <td>FINISH</td> </tr> <tr> <td>SPEC</td> </tr> <tr> <td>DRAWN BY: CLOUGH</td> <td rowspan="4"> 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009 </td> </tr> <tr> <td>CHECKED: DUERFELDT</td> </tr> <tr> <td>OPPS APPR: ANDERSON</td> </tr> <tr> <td>QA APPR: LINDSAY</td> </tr> <tr> <td>APPROVED: GILBERT</td> <td>USED ON MODEL EC145</td> </tr> <tr> <td>SCALE 1:2</td> <td>DATE 1/13/2016 SHEET 1 OF 7</td> </tr> </table>		MAT'L	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125°	HEAT TREAT	FINISH	SPEC	DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	CHECKED: DUERFELDT	OPPS APPR: ANDERSON	QA APPR: LINDSAY	APPROVED: GILBERT	USED ON MODEL EC145	SCALE 1:2	DATE 1/13/2016 SHEET 1 OF 7
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APPROVED: GILBERT	USED ON MODEL EC145														
SCALE 1:2	DATE 1/13/2016 SHEET 1 OF 7														

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	PLUNGER	A36/1018/1020 HR		2
			-3	1	DRIFT	A36/1018/1020 HR		3
			-5	1	GUIDE BUSHING	6061		4
			-7	1	SUPPORT	6061		5
		B/O	-9	1	BOTTOM FOAM	Y20 BLACK	2.08 X 6.04 X 10.54 (I.R. SPECIALTIES)	6
		B/O	-11	1	TOP FOAM	Y20 BLACK	1.08 X 6.04 X 10.54 (I.R. SPECIALTIES)	7
		B/O	-13	1	CASE	PLASTIC	PELICAN CASE #APP-1170-E	N/S
		B/O		1	DART PLACARD	ALUMINUM	RB41011	N/S

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					